

**Work Order ID 52656**

Page 1

October 5, 2009 2:53:11 PM

Item ID: D2528-3

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Backer Plate

Start Date: 06/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

## Reference:

Approvals:	Process Plan: <i>PL</i>	Date: <i>09-10-5</i>	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D2528	Rev C1	

100 *PL* 0.00

FLOW WATER JET

Waterjet

FLOW CNC Waterjet

*SGE2*  
*063*

Memo 0.00

1-Cut as per Dwg D2528  Dwg Rev: *C1*  Prog Rev: *C1*  2-  
Deburr if necessary
*PL* 9-11-6

*57*
*PL 09/11/09*

110 0.00

QC

Quality Control

Memo 0.00

*PL 9-11-6*

120 0.00

QC

Quality Control

Memo 0.00

*27*
*PL 09-10-09*

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Chemical Conversion Coat per QSI005 4.1

0.00

⇒ M 09/11/10

(22)

6

HandFinish

Hand Finishing

Memo

0.00

140



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M11/21/10

⇒ M 09/4/12

(x2)

Powdercoat

Powder Coating

Memo

0.00

START TIME: 10:00AM OVEN TEMPERATURE:  
10:30PM FINISH TIME: 380°F

150



QC3- Inspect Part Finish

0.00

BL 09-11-12

27.

QC

Quality Control

Memo

0.00

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Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg &amp; Stock Location:

0.00

9/11/13

SP

27



Packaging

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

09/11/13



QC

Quality Control

Memo

0.00

MF  
09-11-13

# Picklist Print

Page 1

October 5, 2009 2:53:10 PM

Work Order ID: 52656



Parent Item: D2528-3RevC1



Parent Item Name: Backer Plate

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased		No		110	sf	129.3237	0.3200	1.		

5052-H32 .063 Sheet



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	129.3237	
103755	1.3237	
107276	32	
112442	96	

107276

57

RB 9-11-6

DART AEROSPACE LTD	Work Order:	52654
Description: Backer Plate	Part Number:	D2528-3
Inspection Dwg: D2528	Rev: C1	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>BS</u>	Audited by:	<u>✓</u>	Prototype Approval:	N/A
Date:	9/1/05	Date:	<u>65-11-05</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.03.10	New Issue	KJ/DD	BB



DESIGN KE	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED <del>CP</del>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

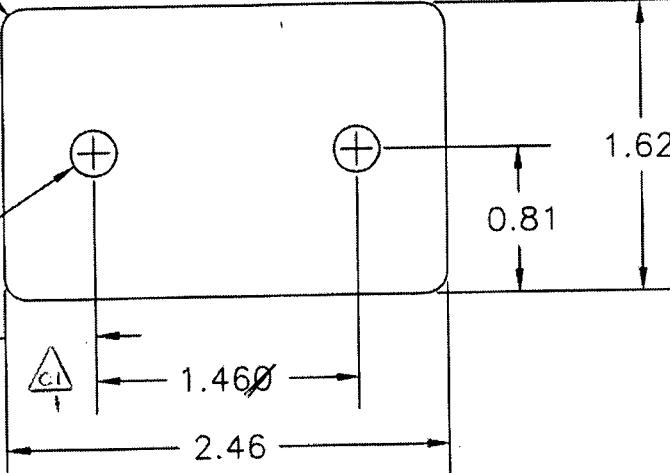
RELEASED  
98.12.11 KE

R0.13 (TYP)

UNDER REVIEW  
~~03.12.03~~

Ø0.257 (TYP)

0.50



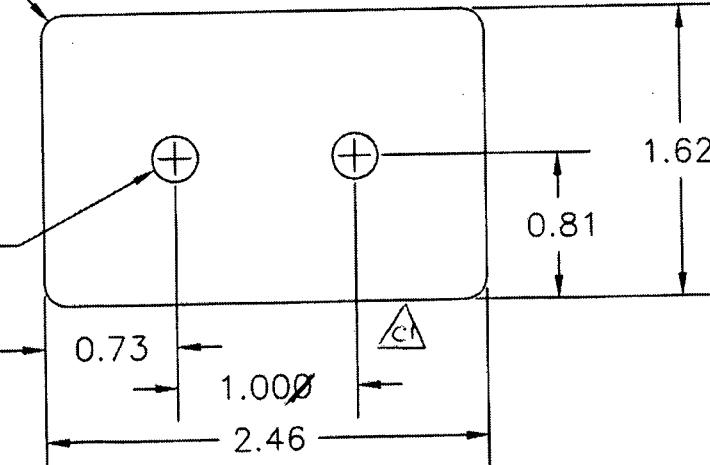
D2528-1

R0.13 (TYP)

Ø0.257 (TYP)

0.73

1.000



D2528-3

SHOP  
RETRIEVE  
ENGINEER  
UNCONTROLLED  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
WORK  
NO. 52654  
Bl 09-10-5

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3  
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED